### Work Order ID 62064



Page 1

Insp.

Stamp

Wednesday, September 15, 2010 2:52:18 PM

Item ID: D3629-1 Accept Setup Start **Revision ID:** Stop Item Name: Bracket Start Otv: 6.00 9/15/2010 Start Date: Cust Item ID: **Required Date: 9/22/2010** Req'd Qty: 6.00 Customer: Reference: Run Start Date: 11-92 Process Plan: Tooling: Approvals: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Reject Tool ID Tool # Plan Accept Reject Description Work Center ID Run Hours Code Qty **Qty** Number Draw Nbr **Revision Nbr** D3629 Rev A 100 0.00 FLOW WATER JET 1310-931 0.00 Waterjet Memo FLOW CNC Wateriet 1-Cut as per Dwg D3629 □Dwg Rev: Deburr if necessary SOU . 063 110 QC2- Inspect parts off machine FAI/FAIB 0.00 16-9-01BH 0.00 Memo **Quality Control** 120 QC8- Inspect parts - second check idonlar

0.00

Memo

Quality Control

# **Dart Aerospace Ltd**

| W/O:    |      | WORK ORDER CHANGES |                      |                              |                       |              |                               |                          |  |  |  |  |  |
|---------|------|--------------------|----------------------|------------------------------|-----------------------|--------------|-------------------------------|--------------------------|--|--|--|--|--|
| DATE    | STEP | PROC               | CEDURE CH            | ANGE                         | Ву                    | Date Qty     | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |  |  |  |  |
|         |      |                    |                      | ;                            |                       |              |                               |                          |  |  |  |  |  |
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|         |      |                    |                      |                              |                       |              |                               | ***                      |  |  |  |  |  |
| Part No | •    | PAR #:             | Fault Ca             | tegory:                      | NCR: Yes              | No DQA:      | Date: _                       |                          |  |  |  |  |  |
|         | R    | esolution:         | _ Disposit           | ion:                         | QA: N/C Closed: Date: |              |                               |                          |  |  |  |  |  |
| NCR:    |      | W                  | ORK OR               | DER NON-CONFORMA             | NCE (NCR)             |              |                               |                          |  |  |  |  |  |
| DATE    | STEP | Description of NC  |                      | Corrective Action Section    |                       | Verification | Approval                      | Approval                 |  |  |  |  |  |
| DAIL    | SIEF | Section A          | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date        | Section C    | Chief Eng                     | QC Inspector             |  |  |  |  |  |
|         |      |                    | ;                    |                              |                       |              | \$                            |                          |  |  |  |  |  |
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## Work Order ID 62064



Page 2

Wednesday, September 15, 2010 2:52:18 PM

Item ID:

D3629-1

Accept



Setup Start



**Revision ID:** 

Item Name:

Bracket

9/15/2010

Start Qty: 6.00

**Req'd Qty:** 6.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Start Date:** 

Approvals:

Process Plan: \_\_\_\_\_ Date:

Tooling:

Date:

Date:

Run

Start

Stop

Stop



Required Date: 9/22/2010

Date:\_\_\_\_\_

SPC (Y/N):

Tool # Plan

Accept

Reject Qty

Insp.

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

1-Bend as per dwg D3629□2-Tumble

Set Up/ **Run Hours** 

Tool ID

Code

Qty

Reject Number

Stamp

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

♦.

| W/O:    |      |        | WORK ORDER      | HANGES   |                |     |                                     |                          |  |  |
|---------|------|--------|-----------------|----------|----------------|-----|-------------------------------------|--------------------------|--|--|
| DATE    | STEP | PR     | OCEDURE CHANGE  | Ву       | Date           | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |
|         |      |        |                 |          |                |     |                                     |                          |  |  |
|         |      |        |                 |          |                |     |                                     |                          |  |  |
|         |      |        |                 |          |                |     |                                     |                          |  |  |
| Part No | :    | PAR #: | Fault Category: | NCR: Yes | s No <b>DQ</b> | A:  | Date: _                             |                          |  |  |
|         |      |        | Disposition:    |          |                |     |                                     |                          |  |  |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                              |                |           |           |              |  |  |  |
|------|------|----------------------------------|----------------------|------------------------------|----------------|-----------|-----------|--------------|--|--|--|
|      |      | Description of NC                |                      | Corrective Action Section B  | Verification   | Approval  | Approval  |              |  |  |  |
| DATE | STEP | Section A                        | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C | Chief Eng | QC Inspector |  |  |  |
|      |      |                                  |                      |                              |                |           |           |              |  |  |  |
|      |      | ·                                |                      | ,                            |                |           | ļ         |              |  |  |  |
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|      |      |                                  | ]                    |                              |                |           | 1         |              |  |  |  |

### Work Order ID 62064

Wednesday, September 15, 2010 2:52:18 PM



Page 3

Item ID:

D3629-1

Accept

Setup Start

**Revision ID:** 

**Start Date:** 

Item Name: Bracket

**Required Date: 9/22/2010** 

9/15/2010

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID: Customer:** 

Reference:

| A        | pprovals:  |  |
|----------|------------|--|
| $\alpha$ | ppi uvais. |  |

Date:

QC:

Date:

Tooling:

**SPC (Y/N):** 

Date: Date:

Start Run

Stop

Stop

Sequence ID/

Work Center ID

160

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Memo

0.00

Quality Control

# **Dart Aerospace Ltd**

| W/O:    |       | WORK ORDER CHANGES |                      |                              |                       |              |        |                               |                          |  |  |  |
|---------|-------|--------------------|----------------------|------------------------------|-----------------------|--------------|--------|-------------------------------|--------------------------|--|--|--|
| DATE    | STEP  | PRO                | OCEDURE CHA          | NGE                          | Ву                    | Date         | Qty    | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |  |  |
|         |       |                    |                      |                              |                       |              |        |                               |                          |  |  |  |
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|         |       |                    |                      |                              |                       |              |        |                               |                          |  |  |  |
| Part No | •     | PAR #:             | Fault Cate           | gory:                        | NCR: Yes              | No <b>DQ</b> | A:     | Date:                         |                          |  |  |  |
|         | Re    | esolution:         | Dispositio           | n:                           | QA: N/C Closed: Date: |              |        |                               |                          |  |  |  |
| NCR:    |       |                    | WORK ORD             | ER NON-CONFORM               | ANCE (NCR             | )            |        |                               |                          |  |  |  |
| DATE    | STEP  | Description of NC  |                      |                              | ion B                 |              | cation | Approval                      | Approval                 |  |  |  |
|         | J J L | Section A          | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date        | Secti        | ion C  | Chief Eng                     | QC Inspector             |  |  |  |
|         |       |                    |                      |                              |                       |              |        |                               |                          |  |  |  |
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|         |       |                    |                      |                              |                       |              |        |                               |                          |  |  |  |

### **Picklist Print**

Wednesday, September 15, 2010 2:52:22 PM

Work Order ID: 62064

Parent Item:

D3629-1 Parent Item Name: Bracket



Start Date: 9/15/2010

Required Date: 9/22/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-07-24 ec

Verified By:JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID   | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|--------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA                       | 1/11); 466/1   10   1641 | Purchased     | No          |                     |                  | 100             | sf                 | 14.1400        | 0.075       | 0.473684     | ر),           |                |        |
| 204/216 Short 063               |                          |               |             |                     |                  |                 |                    |                |             | H            | 310-9-        | 76             |        |

304/316 Sheet .063

Location Loc Qty Loc Code MAT20 14.14 115440

14.14

115688

115688

| Dart Ae | rospace | Ltd               |                      |                              |           |            |         |                                     | ٠ ،                     |  |  |
|---------|---------|-------------------|----------------------|------------------------------|-----------|------------|---------|-------------------------------------|-------------------------|--|--|
| W/O:    |         |                   | WORK ORDER CHANGES   |                              |           |            |         |                                     |                         |  |  |
| DATE    | STEP    | PROCEDURE CHANGE  |                      |                              |           | Date       | Qty     | Approval<br>Chief Eng /<br>Prod Mgr | Approva<br>QC Inspector |  |  |
|         |         |                   |                      |                              |           |            |         |                                     |                         |  |  |
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|         |         |                   |                      |                              |           |            |         |                                     |                         |  |  |
| Part No | :       | PAR #:            | Fault Categ          | ory:                         | NCR: Yes  | No DQ      | A:      | _ Date: _                           |                         |  |  |
|         | Re      | solution:         | Disposition          | _ QA: N/C C                  | losed:    |            | Date: _ |                                     |                         |  |  |
| NCR:    |         |                   | WORK ORDE            | R NON-CONFORMA               | NCE (NCI  | <b>?</b> ) |         |                                     | •                       |  |  |
|         |         | Description of NC |                      | Corrective Action Section    | on B      | Verifi     | cation  | Approval                            | Approval                |  |  |
| DATE    | STEP    | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign Date | & Sect     | ion C   | Chief Eng                           | QC Inspector            |  |  |
|         |         |                   |                      |                              |           |            |         |                                     |                         |  |  |
|         |         |                   |                      |                              |           |            |         |                                     |                         |  |  |
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| DART AEROSPACE LTD           | Work Order: 1/200 | 14     |
|------------------------------|-------------------|--------|
|                              |                   |        |
| Description: Bracket         | Part Number: D362 | 9-1    |
|                              | Page 4            | a.f. 4 |
| Inspection Dwg: D3629 Rev: A | Page 1            | OT_1   |

|  |       | FIRST              | ARTICLE IN          | ISPECTION | ON CHE | CKLIST  |              |          |
|--|-------|--------------------|---------------------|-----------|--------|---------|--------------|----------|
|  |       | X                  | First Artic         | :le       | Proto  | type    |              |          |
| Drawing<br>Dimensio                          |       | Tolerance          | Actual<br>Dimension | Accept    | Reject | Method  |              | mments   |
| Ø0.201                                       |       | +0.005/-0.001      | 509                 | <b>½</b>  |        | UB      | 60           |          |
| 0.88   |       | +/-0.030           | , 88,               | *         |        | V       |              |          |
| 0.465  |       | +/-0.010           | ,462                | *         |        | V       |              |          |
| 0.375  |       | +/-0.010           | 377                 | *         |        | V       |              |          |
| 3.070  |       | +/-0.010           | 3.069               | *         |        | V       |              |          |
| 4.00   |       | +/-0.030           | 4.001               | ×         |        | ٧       |              |          |
| 2.125  |       | +/-0.010           | 3.138               | 7         |        | V       |              |          |
|  |       |                    |                     |           |        |         |              |          |
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| Measured by                                  | : 17  | 2                  | Audited by:         | 2         |        | Prototy | pe Approval: | N/A      |
| Date   | - -{1 | 10-9-21            |                     | 10/09b    |        |         | Date:        | N/A      |
| Rev         Date           A         08.05.0 |       | hange<br>lew Issue |                     |           |        |         | Revised by   | Approved |

H:\FORMS\Quality Assurance\approved QA\FAI revD

| V/O: |      | WORK ORDER CH    | IANGES |      |     | Approval                | Approval     |
|------|------|------------------|--------|------|-----|-------------------------|--------------|
| DATE | STEP | PROCEDURE CHANGE | Ву     | Date | Qty | Chief Eng /<br>Prod Mgr | QC Inspector |
|      |      |                  |        |      |     |                         |              |
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|          |             |                 |                | DO 4. | Date: |
|----------|-------------|-----------------|----------------|-------|-------|
| Part No: | PAR #:      | Fault Category: | NCR: Yes No    | DQA:  | Date. |
| Fait 110 |             |                 | QA: N/C Closed | ł: _  | Date: |
|          | Resolution: | Disposition:    | QA. 100 010000 |       |       |

| NCR: |      |                                | Corrective Action Section B |                              |                | Verification | Approval  | Approval   |
|------|------|--------------------------------|-----------------------------|------------------------------|----------------|--------------|-----------|--|
| DATE | STEP | Description of NC<br>Section A | Initial<br>Chief Eng        | Action Description Chief Eng | Sign &<br>Date | Section C    | Chief Eng | QC Inspecto                                      |
|      |      |                                |                             |                              |                |              |           |  |
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|--|---------------------|----------|--------------------|--------|-------------|-------------|----------|
|  | DESIGN DRAWN BY     |          | DART AEROSPACE LTD |        |             |             |          |
|  |                     | 4   _4   |                    | 3      | HAWKESE     |             |          |
|  | CHECKE              | D        | APPRO              | /ED    | DRAWING NO. |             | REV. A   |
|  | PH                  | <i>†</i> | 9t                 | t      | D3629       | SHEE        | T 1 OF 1 |
|  | DATE                |          |                    |        | TITLE       |             | SCALE    |
|  | 07.05.10            |          |                    |        | BRACKET     |             | 1:2      |
|  | REV DATE A 07.05.10 |          |                    |        |             | DESCRIPTION |          |
|  |                     |          |                    | .05.10 | NEW ISSUE   |             |          |

RELEASED 07.07

SHOP COPY

RETURNTO

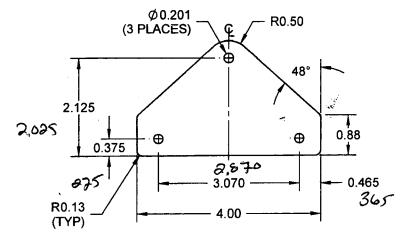
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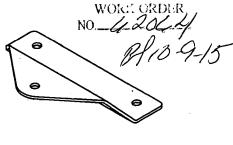
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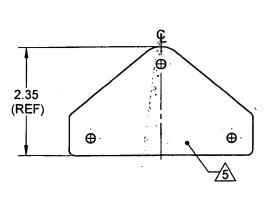
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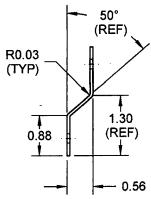
WORK ORDER





## **D3629-1F BRACKET FLAT PATTERN**





### D3629-1 BRACKET (MAKE FROM D3629-1F)

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.063 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)

2) FINISH: NONE

3) PART IS SYMMETRIC ABOUT &

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) IDENTIFY WITH DART P/N "D3629-1" USING FINE POINT PERMANENT INK MARKER

6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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# **Dart Aerospace Ltd**

| W/O:      |      | WORK ORDER CHANGES            |                             |                              |                |              |                        |                               |                          |  |  |  |
|-----------|------|-------------------------------|-----------------------------|------------------------------|----------------|--------------|------------------------|-------------------------------|--------------------------|--|--|--|
| DATE STEP |      | PROCEDURE CHANGE              |                             |                              |                | Date         | Qty                    | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |  |  |
|           |      |                               |                             |                              |                |              |                        | Prod Mgr                      |                          |  |  |  |
|           |      |                               |                             |                              |                |              |                        |                               |                          |  |  |  |
|           |      |                               |                             |                              | '              |              |                        |                               |                          |  |  |  |
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|           | :    |                               |                             |                              |                |              |                        |                               |                          |  |  |  |
| Part No:  |      | PAR #:                        | PAR #: Fault Category: N    |                              |                |              | NCR: Yes No DQA: Date: |                               |                          |  |  |  |
|           | R    | esolution:                    | ution: Disposition:         |                              |                |              | QA: N/C Closed: Dat    |                               |                          |  |  |  |
| NCR:      |      |                               | WORK ORD                    | ER NON-CONFORMA              | NCE (NCF       | ₹)           |                        |                               |                          |  |  |  |
|           | STEP | P Description of NC Section A | Corrective Action Section B |                              |                | Verification |                        | n Approval                    | Approval                 |  |  |  |
| DATE      |      |                               | Initial<br>Chief Eng        | Action Description Chief Eng | Sign &<br>Date | k Sect       | ion C                  | Chief Eng                     | QC Inspector             |  |  |  |
|           |      |                               |                             |                              |                |              |                        |                               |                          |  |  |  |
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